

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2017-15** Date Opened: **18 Jan 2017** Title: **Assembly**Aircraft OEM: Eurocopter Aircraft Model: **AS350** Product Type: **Cargo Basket** Product Model: **XL Ski** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
94010	1	Basket Assembly	JC
70405	4	Lid Walkway Mod.	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
94027	1	Placard	JC
84261	2	Handle Assembly	JC

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

JC
JC
JR
JR
JR
JR
JC

Work performed by:

Print: J. Rekve

Sign: 

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign: 

Work Order closed by:

Print: J. Clarke

Sign: 

Approved Manufacturing Facility 73-04

Form 20.D.03

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

SCA: AD01

Date: 18-Jan-17

SCA: AD02

Date: 18-Jan-17

SCA: AD02

Date: 18-Jan-17

Rev. Original 23 Sep 2014

2016-84



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Alt:

All

Model: All

Description:

Hinge

Supplier:

Bisco Industries

Color:

N/A

WO#:

N/A

PO# 16030



# Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 100  
PN: CR3523-5-02  
Aircraft: Multiple Model: Multiple  
Description: Rivet  
Supplier: Bisco  
Color: N/A  
WO#: N/A PO# 16005

**CHERRY** AEROSPACE  
1224 E. Warner Ave. Box 2167  
Santa Ana, CA 92707-0167

ACCEPT NO SUBSTITUTES®

FSCM 11815 CHERRYMAX®

06/25/15 - IR

Part Number

CR3523PR-5-02

CR3523-5-02

FAA-TSO-C148

FAA-TSO-C148

Lot Number

88080496

Hole Size

.160-.164

Grip Range

.063-.125

QTY:

100

ALSO IN FULL COMPLIANCE WITH THE FOLLOWING  
NON-TSO PART NUMBER(S)

132269B502

MBBN3012M4002

CAN43078M5-2

ASNA0078E502

NAS9307M-5-02

M7885/4-5-02

B0207005M5-02

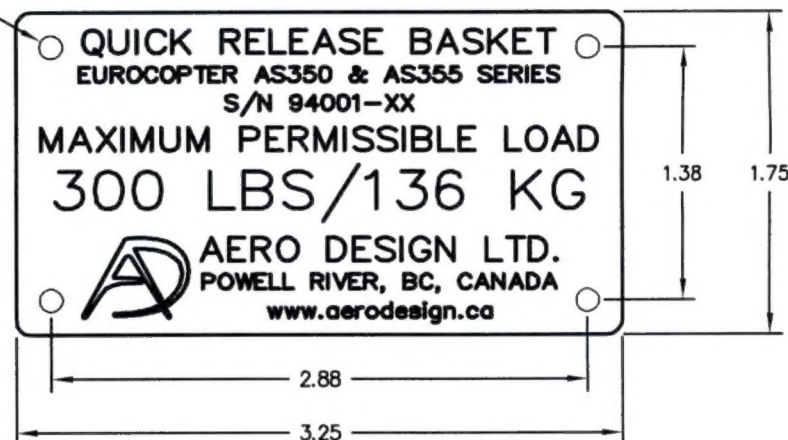


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO; MAT'L THICKNESS CHANGED	BJC	10/07/2014

# NOTES


- ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
"S/N 94001-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"300 LBS/136 KG" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"POWELL RIVER, BC, CANADA" - 0.080 HIGH  
"www.aerodesign.ca" - 0.080 HIGH

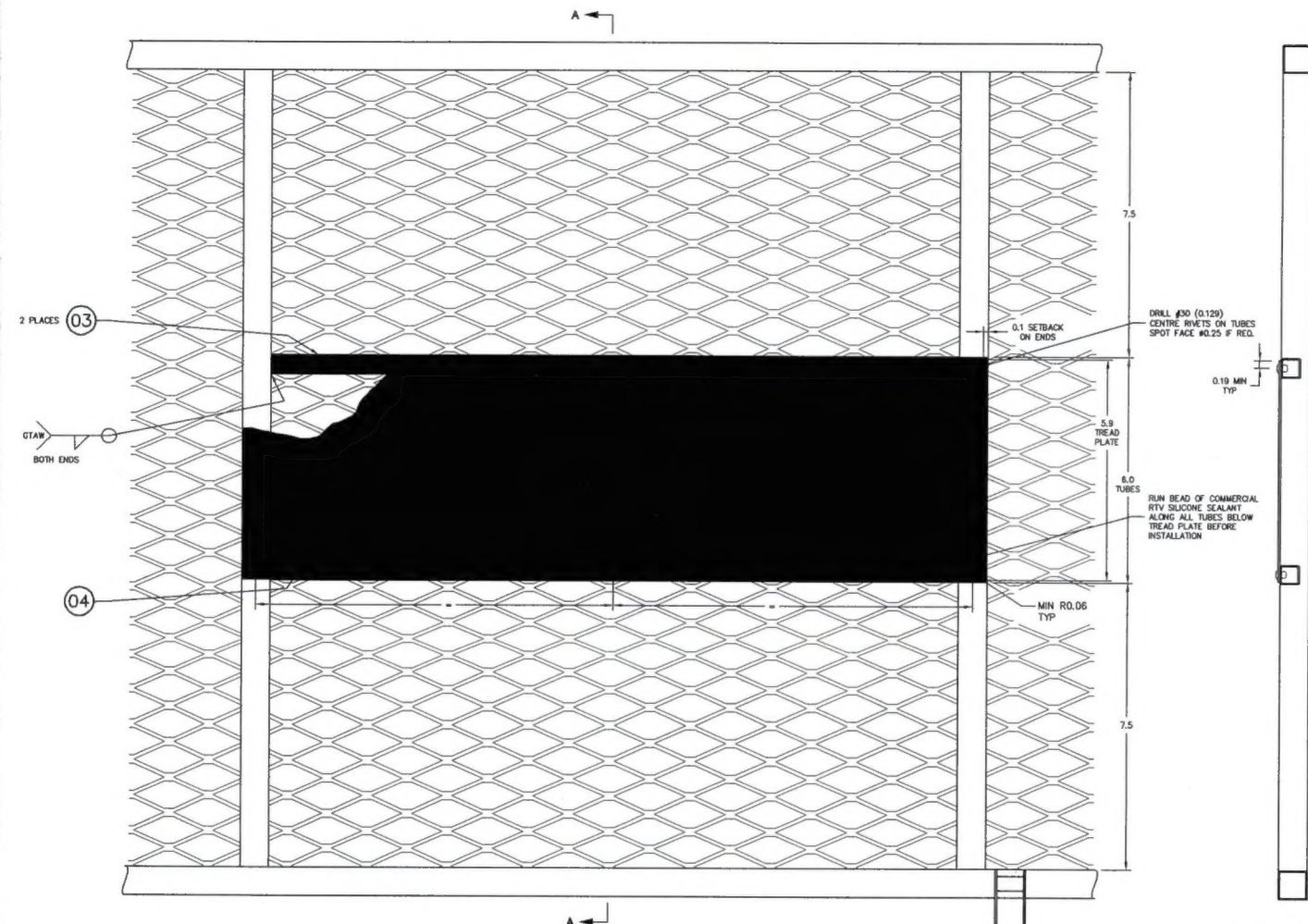
DRILL #30 (0.129)  
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS					

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	DRAWN: R. RATHWELL		OCT 3, 2011			9888A MALASPINA ROAD							
	CHECKED: E. BURGAIN					POWELL RIVER, BC, CANADA, V8A 0G3							
							TEL: 604.483.2376 <a href="http://www.aerodesign.ca">www.aerodesign.ca</a>						
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD							
						SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
						SHEET 1 OF 1		A4		94027		1	



(01) BASKET LID ASSEMBLY

SECTION A-A

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 288SC. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02
1	70405-04	04 TREAD PLATE	ALUMINUM
2	70405-03	03 TUBE	4130 STEEL COND. N
1	SEE NOTE 1	02 BASKET LID ASSEMBLY	MIL-T-6736
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP	0.063 TREAD PLATE
01	PART NO.	ITEM	DESCRIPTION
			MATERIAL
			MATERIAL SPEC
			STOCK SIZE

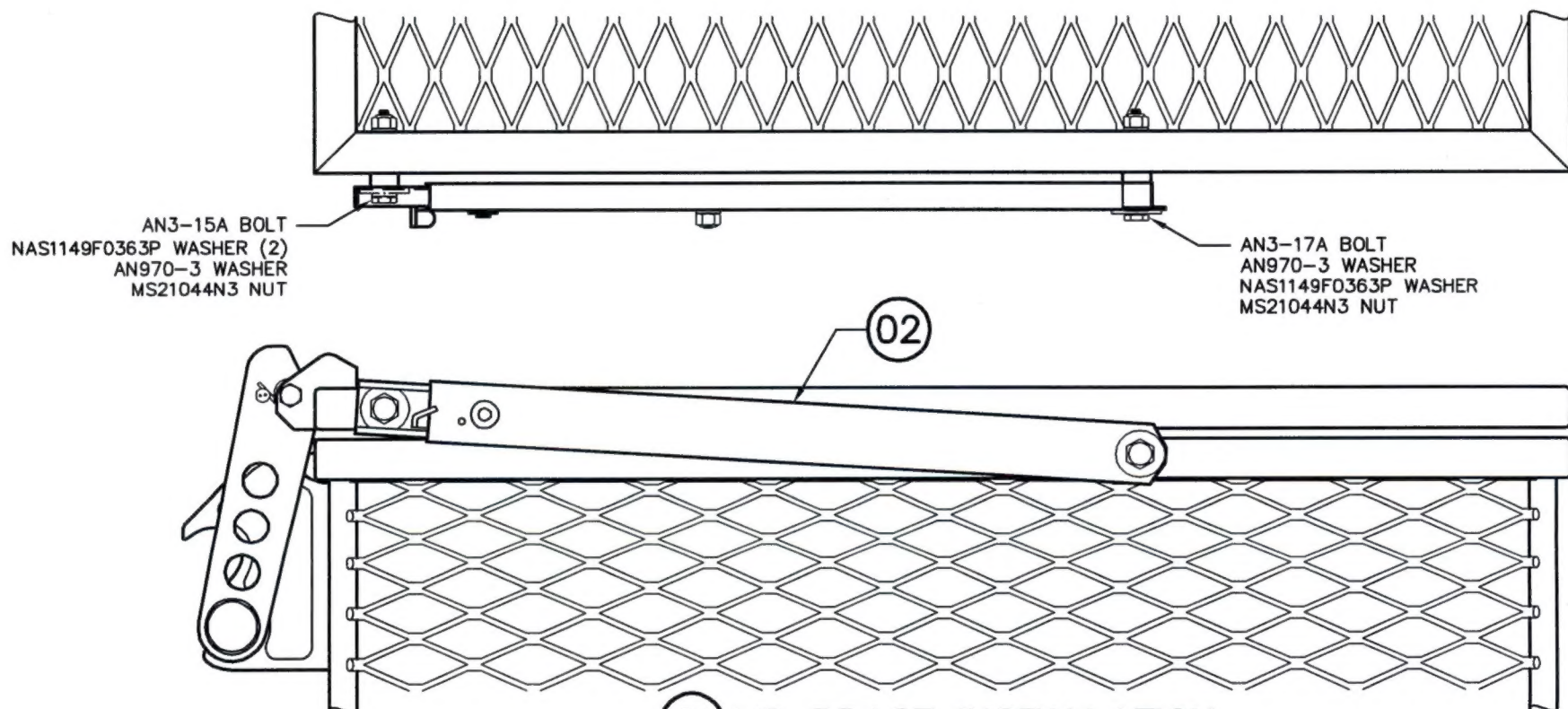
LIST OF MATERIALS

BASIC CODE REF. NAS 523 C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR DIAMETER N=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE  DASH NO. FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE CHECKED: E. BURGON		DATE 21 SEPT 2006	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARN=CR3213 ARM=CR3212		+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		ANGLES ±1/2"	
AERO DESIGN LTD. 8888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 804.483.2878 www.aerodesign.ca				CARGO BASKET LID STEP MODIFICATION			
SCALE 1 : 1.5 SHEET 1 OF 1		DIM. SIZE A1		DIM. NO. 70405		REV. 4	



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



## (01) LID BRACE INSTALLATION

### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

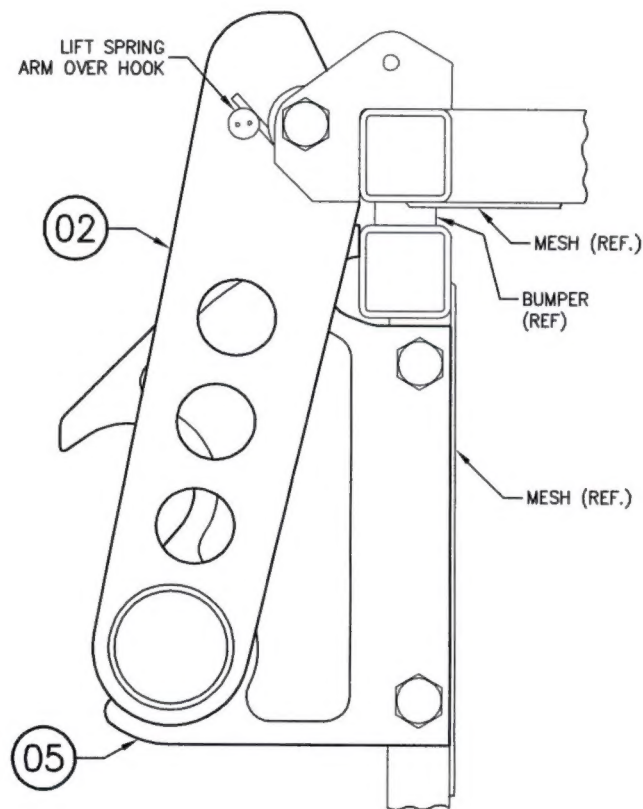
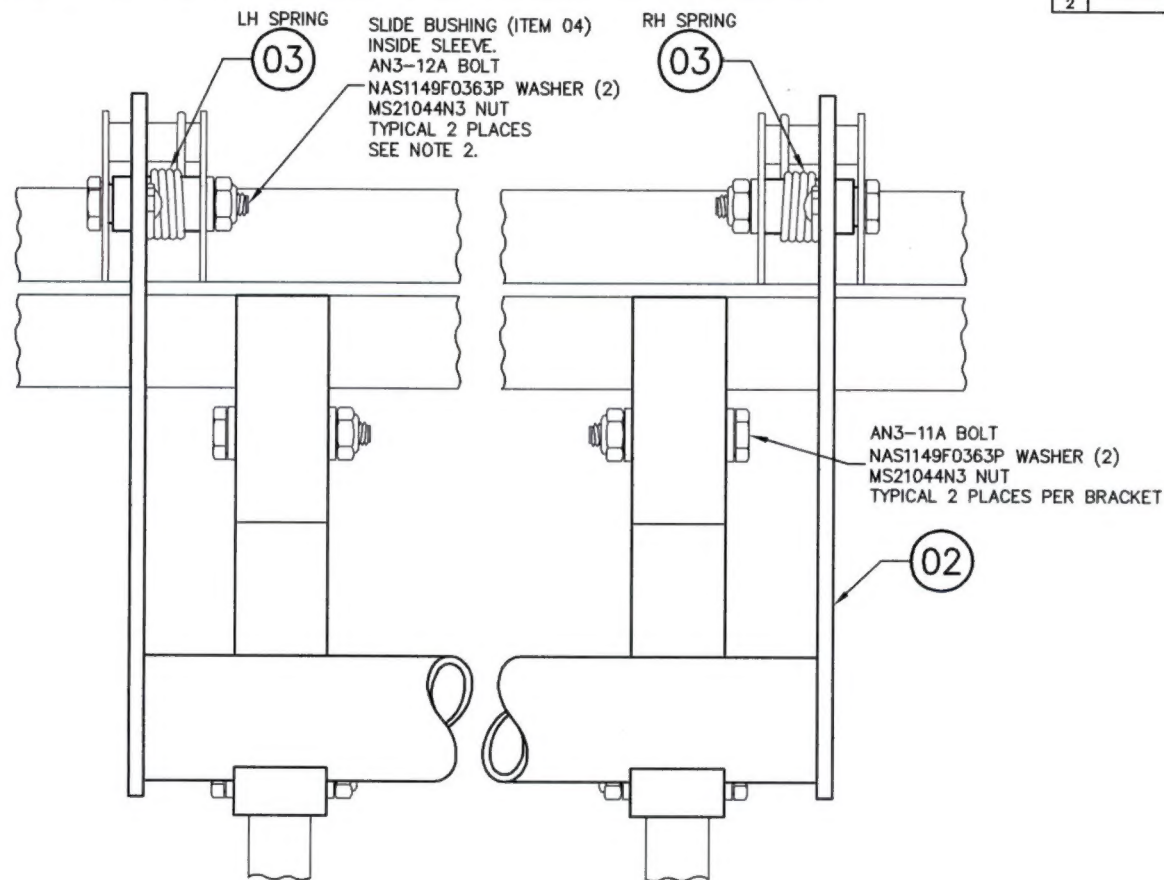
2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2° X.XX ±0.03 X.X ±0.1	

 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.683.2370      www.aerodesign.ca		<b>HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION</b>	
		NOT TO SCALE	REV.
DWG. SIZE	DWG. NO.		
A4	84240		0
SHEET 1 OF 1			

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

01 HANDLE INSTALLATION

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGOIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX  $\pm 0.010$   $\pm 1/2^\circ$   
X.XX  $\pm 0.03$   
X.X  $\pm 0.1$



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.483.2376 www.aerodesign.ca

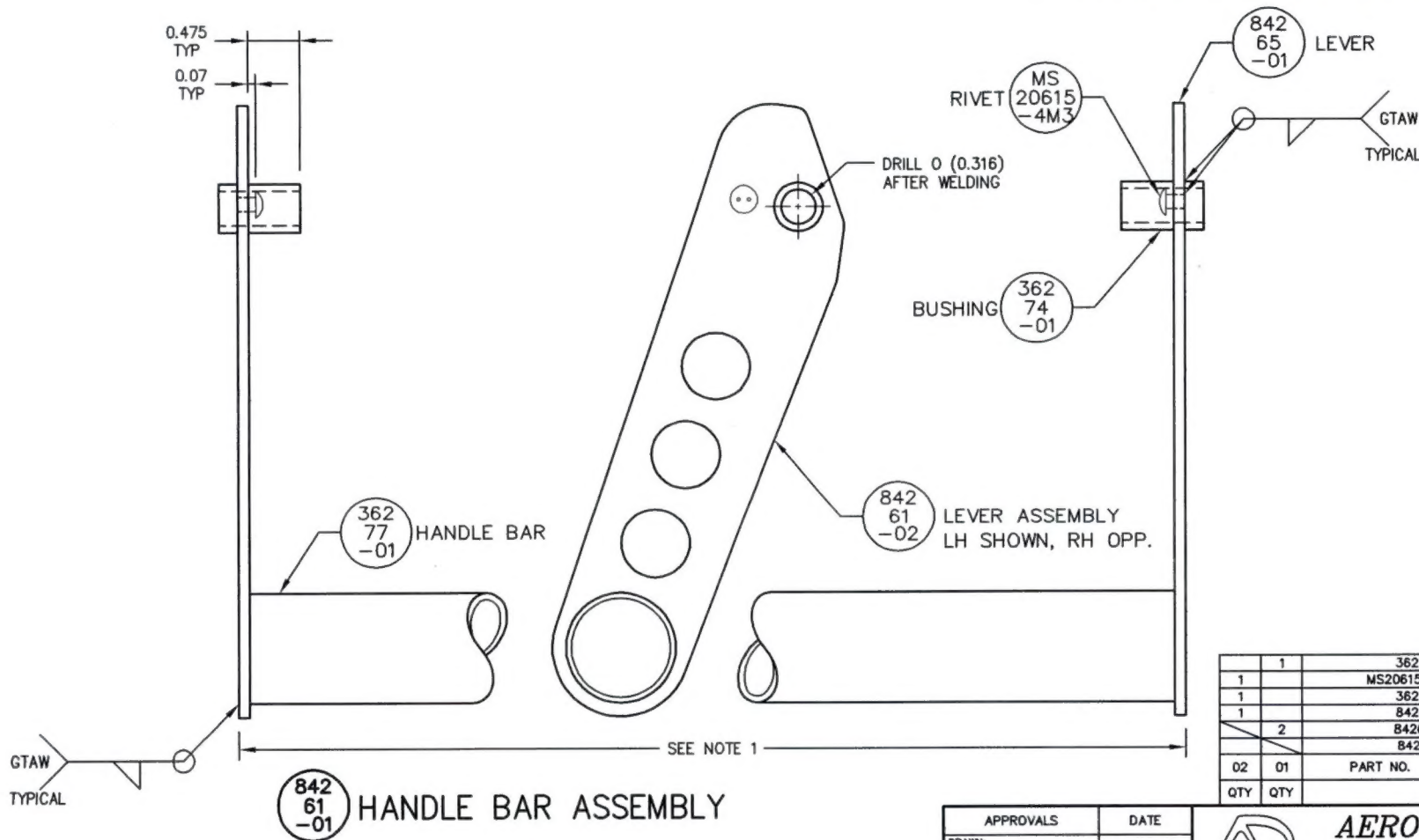
**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



1	36277-01	HANDLE BAR
1	MS20615-4M3	RIVET (MONEL)
1	36274-01	BUSHING
1	84265-01	LEVER
2	84261-02	LEVER ASSEMBLY (RH/LH)
2	84261-01	HANDLE BAR ASSY
QTY	QTY	DESCRIPTION

NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1

 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.8376 www.aerodesign.ca			
<b>HELICOPTER CARGO BASKET HANDLE BAR ASSEMBLY</b>			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84261	2

Work Order: 2017-15Date Opened: 18 JAN 2017

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Assembly

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		94010-01	<b>Cargo Basket Assembly</b>	S/N 94001-67	
<b>Step 1</b>				<i>Lid Assembly</i>		
	1		94012-01	Basket Lid Assembly		2016-84
Step 1.a.	4		49205-14	Bumper	Argus Industries Bumper	
	A/R	--		Sealant	Commercial Silicone RTV sealant	
Step 1.b.	1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	2015-03
	4		CR3213-4-02	Cherry Rivet		16042
Step 1.c.	1		70405-01	Lid Step Modification		
(option)	1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	16017
	A/R		CR3213-4-02	Cherry Rivet		16042
	A/R	--		Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	1		94011-01	Basket Body Assembly		2016-84
	4		96710-01	Fitting	Alternate: Ancra 40088-14	
	8		AN960-616	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	1		MS20001P4	Piano Hinge	95"	16030
	8		CR3523-5-02	Cherry Rivet		16005
	A/R		CR3213-5-02	Cherry Rivet		16042
<b>Step 4</b>	1		84255-01	<i>Handle Installation</i>		
Step 4.a.	2		84267-01	Bracket	Delrin, 3/4" Sheet	2016-37
	4		AN3-11A	Bolt		
	8		NAS1149F0363P	Washer		
	4		MS21044N3	Nut		

Work Order: 2017-15Date Opened: 18 JAN 2017Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		<i>See attached.</i>
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				<i>Lid Brace Installation</i>		
	. 1		36280-01	Brace Assembly		<i>2916-145</i>
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				<i>Inspection</i>	<i>None</i>	



Work Order: 2017-15Date Opened: 18 JAN 2017Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Handle Assembly

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>	84261	<b>84261-01</b>	<b>Handle Assembly</b>		
<b>Step 1</b>				<i>Weld Lever Assembly</i>		<i>2015-122</i>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R			Welding Rod	ER308L TIG Rod	
<b>Step 2</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	<i>15073</i>
<b>Step 4</b>				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
<b>Step 5</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection - Final Assembly</i>	<i>None</i>	

## Aero Design

### Parts Distribution Sheet

Description: Basket Assembly Kit

WO# \_\_\_\_\_

[illegible]

## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

**All Models:** 84261, Rev. 1

Work Order: 2017-15

**Complete**  
(initial or SCA #)

Date Open: 18 JAN 2017

Previously C/W

1. Weld Lever Assembly – handle lever jig required
  - a. Set MS20615-4M3 monel rivet into socket in jig
  - b. Set 36274-01 bushing into socket in jig
  - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
  - d. TIG weld around bushing using ER308L rod.
  - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
  - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
  - g. Record material POs on attached material list.

2. Clean up
  - a. Clean lever assembly by media blasting with glass bead.
  - b. Drill out lever bushing to O (0.316) on lathe:
    - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
    - ii. Run at 300 RPM.
    - iii. Apply a drop of Rapid-Tap to drill.
  - c. De-burr.

AD  
73-04  
01

3. Fabricate Handle Assembly
  - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
  - b. Measure across TOP side of levers.
  - c. Cut handle tubing to length measured.
    - i. Handles under 40" long: 1.0" x 0.035 round tube
    - ii. Handles over 40" long: 1.0" x 0.065 round tube
  - d. De-burr tube.
  - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
  - f. Record material PO on attached material list.

AD  
73-04  
05

4. Weld Handle Assembly
  - a. Fuse tube to lever on both ends. Ensure levers are parallel.

AD  
73-04  
07

5. Clean up
  - a. Clean welded area with scotch-brite.

6. Final Inspection –

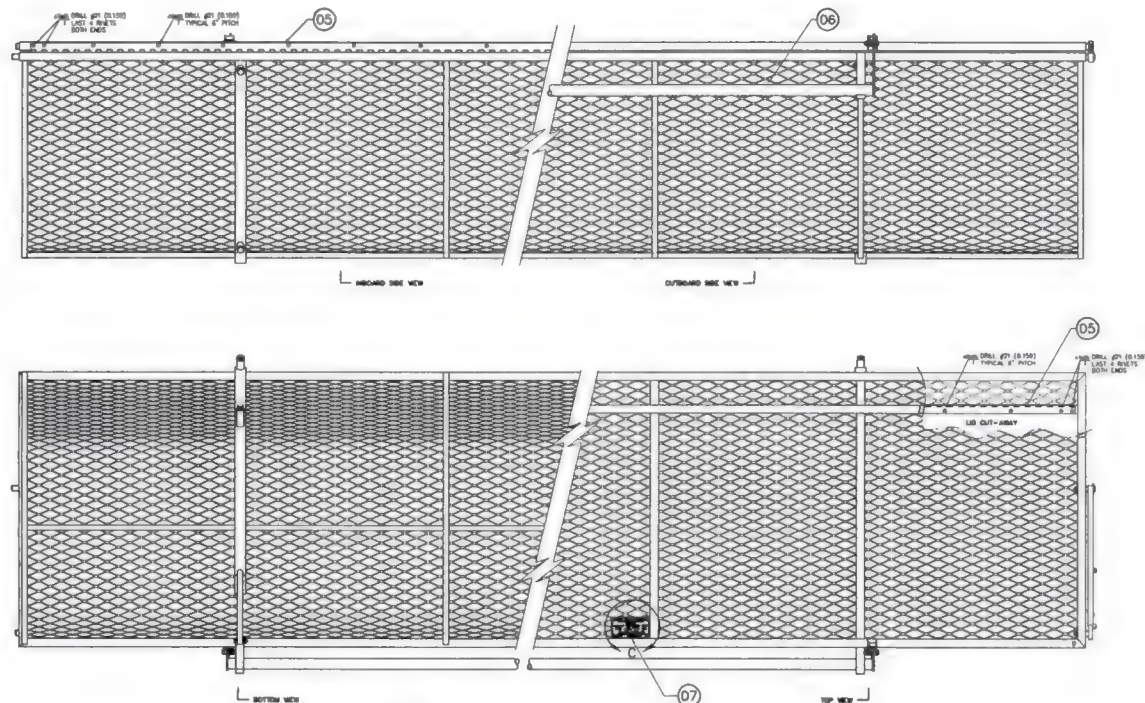
To be completed by a different person than the previous steps.

  - a. Welds for complete and handle for fit.
  - b. Tag complete and inspected parts in preparation for installation.

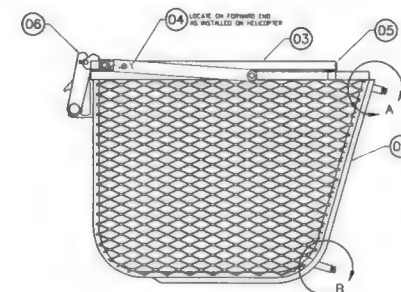
AD  
73-04  
02



REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	UPDATE TITLE BLOCK AND ALTERNATE PARTS HARDWARE PLANS UPDATED.	ASL	10/01/2000
2	CHANGE BRACE ASSEMBLY TO INSTALLATION		

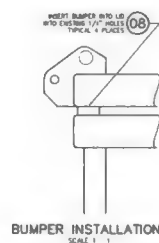


94010-01 CARGO BASKET ASSEMBLY - RH



DETAIL A  
TYPICAL FRONT AND REAR

DETAIL B  
TYPICAL FRONT AND REAR



BUMPER INSTALLATION  
SCALE: 1:1



DETAIL D  
LOOKING AT PLACED BRACKET

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
2	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
3	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
4	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
5	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
6	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
7	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
8	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
9	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"
10	QUICK RELEASE BASKET	ALUMINUM	6061-T6	30" X 48" X 48"

BASIC CODE REF: 94010-01		DATE 30 OCT 2001		USE OF MATERIALS	
DRAWING NO. 94010-01 CHANGES					


AERO DESIGN LTD.

8000A MALASPINA ROAD  
POWELL RIVER, BC CANADA V8A 0G3  
TEL: 250.468.0878

EUROCOPTER AS350 & AS355 SERIES  
QUICK RELEASE CARGO BASKET  
BASKET ASSEMBLY (EXTRA LARGE)

SCALE: 1:1

SHEET 1 OF 1

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2017-0039</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2017-15</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket</b>	8. Part Number <b>94010-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>94001-67</b>	11. Status/Work <b>New</b>
12. Remarks <b>Modified with walkway on lid IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release</del> <del><input type="checkbox"/> Other regulation specified in block 12</del> <del>Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del> <del>14c. Approved Organization Number</del>	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>18 Jan 2017</b>		<del>14d. Name</del> <del>14e. Date (dd/mm/yyyy)</del>	
<b>Installer Responsibilities</b>					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

DELTA HELICOPTERS

## **CARGO BASKET ASSEMBLY - COMMON**

### **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket

94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway



AS350 XL SK1

**CARGO BASKET ASSEMBLY - COMMON**

**Complete**  
(initial or SCA #)

Work Order: 2017-15

Date Open: 18 JAN 2017

AD02

**1. Lid Assembly**

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

**2. Body Assembly**

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

## 'CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation

AD02

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations



**\*CARGO BASKET ASSEMBLY - COMMON**

**Complete**  
(initial or SCA #)

*dk*

- d. Record PO of hinge and rivets on attached material tracking list.

**4. Install Handle**

a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

**5. Install lid brace**

*AD02*

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.



**CARGO BASKET ASSEMBLY - COMMON**

**Complete**  
(initial or SCA #)

AD02

**6. Final Inspection**

Dual inspection by a different person than assembled the basket.

**a. Check for general condition and correct assembly:**

- i. Bolts are tight
- ii. Rivets are installed correctly *ok*
- iii. Handle operates correctly
- iv. Lid brace operates correctly

**b. Check that PO/WO numbers have been recorded.**